

*Split*

Work Order ID 101883-2

May-21-13 7:44:39 AM

\*101883\*

Page 1

Item ID: D3975-042

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Item Name: Gas Cylinder Assembly, RH

Start Date: 5/21/13 Start Qty: 5.00

\*5\*

Cust Item ID:

Required Date: 5/28/13 Req'd Qty: 5.00

\*5\*

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 13-05-21

Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3975	B								

110

\*110\*

Small Fab

Small Fab

0.00

3

FF  
13-10-21

Memo

0.00

apply decal as per dwg

120

\*120\*

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

DAS

27

9-89

13-10-21

3

130

\*130\*

Packaging

Packaging

Identify as per dwg & Stock Location: ST080

0.00

Memo

0.00

3x

DAS  
28  
9-89

13-10-21

NCR: Yes / No

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
			Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>				
Part No. _____			Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>				
NCR No. _____			Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>				
Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector	
Doc/Data	<input type="checkbox"/>										
Equip/Tooling	<input type="checkbox"/>										
Operator	<input type="checkbox"/>										
Material	<input type="checkbox"/>										
Setup	<input type="checkbox"/>										
Other	<input type="checkbox"/>										
Process	<input type="checkbox"/>										
Supplier	<input type="checkbox"/>										
Training	<input type="checkbox"/>										
Unapproved	<input type="checkbox"/>										
FAULT CATEGORY											
Landing Gear				General							
<input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				<input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio				<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			
								<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge			
								<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled			
								<input type="checkbox"/> Other			

Work Order ID: 101883

May-21-13 7:44:39 AM

\*101883\*

Page 2

Item ID: D3975-042

Accept

Revision ID:

Item Name: Gas Cylinder Assembly, RH

Start Date: 5/21/13 Start Qty: 5.00 \*5\*

Required Date: 5/28/13 Req'd Qty: 5.00 \*5\*

\*N900040100\*

Setup Start

\*NS1\*

Stop \*NS2\*

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

140

\*140\*

QC

Quality Control

Operation  
Description

QC21- Final Inspection - Work Order Release

Set Up/  
Run Hours

0.00

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Memo

0.00

*[Handwritten signatures and notes]*

NCR: Yes / No

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____ Part No. _____ NCR No. _____				<b>DISPOSITION</b>		<b>AGAINST DEPARTMENT/PROCESS</b>						
				Rework <input type="checkbox"/>	Scrap <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>			
				Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>			
				Work Order Update <input type="checkbox"/>		Finishing <input type="checkbox"/>	Composite <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>			
<b>Root Cause</b>		Date	Step	Qty	Description of work order update or Non-conformance		Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector	
Doc/Data <input type="checkbox"/> Equip/Tooling <input type="checkbox"/> Operator <input type="checkbox"/> Material <input type="checkbox"/> Setup <input type="checkbox"/> Other <input type="checkbox"/> Process <input type="checkbox"/> Supplier <input type="checkbox"/> Training <input type="checkbox"/> Unapproved <input type="checkbox"/>												
<b>FAULT CATEGORY</b>												
<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio		<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions				<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled

Picklist Print

May-21-13 7:44:43 AM

Page 1 / 1

Work Order ID: 401883

\*101883\*

Parent Item: D3975-042

\*D3975-042\*

Parent Item Name: Gas Cylinder Assembly, RH

Start Date: 5/21/13

Required Date: 5/28/13

Comments: IPP RevA: New issue DD verified by:EC  
10.05.27 as per ECN10-548 DD verf EC

IPP Rev:B

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3975-1		Manufactured	No			110	Each	10.0000	1	5			

\*D3975-1\*

Gas Cylinder

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FF

13-10-21

Location	Loc Qty	Loc Code
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GA	10	
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91873

10

10

E3

D3976-3

\*D3976-3\*

Decal

Manufactured

No

110	Each	2.0000	1	5
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FF

13-10-24

Location	Loc Qty	Loc Code
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ST081	102065	2		
-------	--------	---	--	--

60431

	2		
--	---	--	--

3

2

51371  
102065

NCR: Yes / No

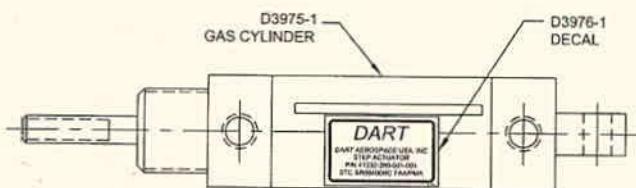
## WORK ORDER NON-CONFORMANCE / UPDATE

DQA: Date:

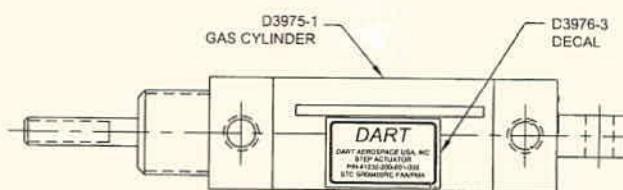
QA Closed: Date:

Work Order: _____				DISPOSITION		AGAINST DEPARTMENT/PROCESS					
				Rework Scrap Use-as-is Work Order Update	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other			
Part No. _____ NCR No. _____											
Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector	
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear				General							
Bending		Bend		Grain		Ovalized		Pressure/Forced			
Centre Not Concentric to O/S		BOM/Route		Hardware		Over/Under tolerance		Temperature/Cure			
Cracks		Broken/Damaged		Inspection Incomplete		Part Incorrect		Weld			
Crushed/Crimped		Burrs		Instructions Incomplete/Unclear		Part Lost/Missing		Wrong Stock Pulled			
Cuffs		Contamination		Maintenance		Part Moved					
Heat Treat		Countersink		Mislabeled		Positioned Wrong					
Inspection Strip in Tube		Cut Too Short		Misread		Power Loss/Surge					
Ripples in Bend		Drill Holes		Offset							
Torque Waves in Extrusion		Drawing		Out of Calibration							
Turning Sequence		Finish		Out of Sequence							
Wave/Twist in Tube		Folio		Outside Dimensions							

ITEM No.	QTY -041	QTY -042	PART NUMBER	DESCRIPTION
1	X		D3975-041	GAS CYLINDER ASSEMBLY (LH)
2	X		D3975-042	GAS CYLINDER ASSEMBLY (RH)
3	1	1	D3975-1	GAS CYLINDER
4	1		D3976-1	DECAL
5		1	D3976-3	DECAL



D3975-041 GAS CYLINDER ASSEMBLY



D3975-042 GAS CYLINDER ASSEMBLY

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDERS

NO. 101883 MLJ  
13-05-21

RELEASED  
2010-05-20

B	CORRECTED TYPO: D3976-3 WAS D3975-3 (ZN D7-1)	MB	10.04.13
A	NEW ISSUE	AJS	09.07.09
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE USA, INC	
DRAWN		PORT HADLOCK, WA	
CHECKED	PP	DRAWING NO.	REV. B
MFG. APPR.	PP	D3975	SHEET 1 OF 2
APPROVED	PP	TITLE	SCALE
DE APPR.	PP	GAS CYLINDER ASSEMBLY	NTS
DATE	10.04.13	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS CONDITION THAT IT BE NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

NCR: Yes / No

## WORK ORDER NON-CONFORMANCE / UPDATE

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

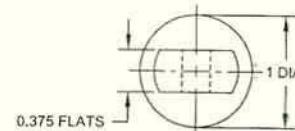
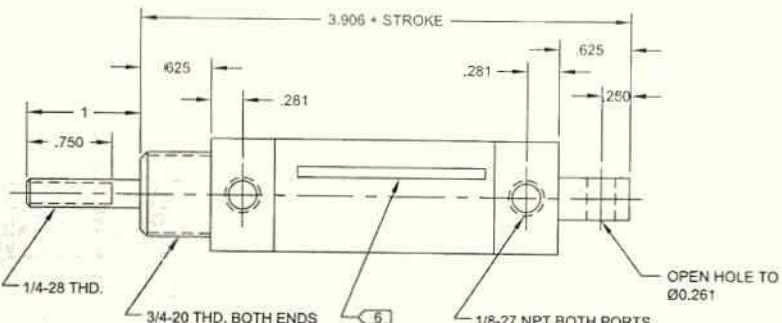
Work Order: _____	<b>DISPOSITION</b>			<b>AGAINST DEPARTMENT/PROCESS</b>						
Part No. _____	Rework	<input type="checkbox"/>	Skid-tube	<input type="checkbox"/>	Crosstube	<input type="checkbox"/>	Water Jet	<input type="checkbox"/>	Engineering	<input type="checkbox"/>
NCR No. _____	Scrap	<input type="checkbox"/>	Machining	<input type="checkbox"/>	Small Fab	<input type="checkbox"/>	Prod. Eng. Coor.	<input type="checkbox"/>	Quality	<input type="checkbox"/>
	Use-as-is	<input type="checkbox"/>	Thermoforming	<input type="checkbox"/>	Finishing	<input type="checkbox"/>	Rec/Store/Packaging	<input type="checkbox"/>	Other	<input type="checkbox"/>
	Work Order Update	<input type="checkbox"/>	Large Fab	<input type="checkbox"/>	Composite	<input type="checkbox"/>	Supplier	<input type="checkbox"/>		

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

## FAULT CATEGORY

Landing Gear	Bending	General	Grain	Ovalized	Pressure/Forced
	Centre Not Concentric to O/S		Hardware	Over/Under tolerance	Temperature/Cure
	Cracks		Inspection Incomplete	Part Incorrect	Weld
	Crushed/Crimped		Instructions Incomplete/Unclear	Part Lost/Missing	Wrong Stock Pulled
	Cuffs		Maintenance	Part Moved	
	Heat Treat		Mislabeled	Positioned Wrong	
	Inspection Strip in Tube		Misread	Power Loss/Surge	Other
	Ripples in Bend		Offset		
	Torque Waves in Extrusion		Out of Calibration		
	Turning Sequence		Out of Sequence		
	Wave/Twist in Tube		Outside Dimensions		

101883

D3975-1 BRASS CYLINDER**NOTES:**

- 1) MATERIAL: CROSS REFERENCE Era DRAWING 41232-200-007  
PURCHASE P/N: HEAVY DUTY BRASS CYLINDER 7D1H  
VENDOR: CLIPPARD INSTRUMENT LABORATORY, INC. CINCINNATI, OH.
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH Era P/N 41232-200-007-001 USING VIBRATING STYLUS
- 7) WEIGHT: 0.74 lbs APPROX
- 2) BORE: 0.675 INCHES
- 3) ROD: ROTATING
- 4) 7D1H CONFIGURED WITH HYD. FLUID SEALS.
- 5) TEMPERATURE RANGE: 30° F TO 230° F.
- 6) MOUNT: UNIVERSAL MOUNT.
- 7) ACTION: DOUBLE ACTING.
- 8) STROKE: 1.000 INCH.
- 9) POWER FACTOR: 0.6 SQ. IN.
- \*0) PORTS: 1/8 NPT.
- 11) ROD DIAMETER: .25 INCHES.
- 12) SINTERED BRONZE ROD BUSHING.
- 13) PRESSURE TEST: 2660 PSI (USE 5606 FLUID).

**RELEASED**  
2010-05-20 *[Signature]*

DESIGN	<i>AS</i>	DART AEROSPACE USA, INC	
DRAWN	<i>AS</i>	PORT HADLOCK, WA	
CHECKED	<i>AS</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>AS</i>	D3975	SHEET 2 OF 2
APPROVED	<i>AS</i>	TITLE	SCALE
DE APPR.	<i>AS</i>	GAS CYLINDER ASSEMBLY	NTS
DATE	10.04.13	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PROPERTY AND CONFIDENTIAL AND IS SUPPLIED BY THE COMPANY CONFINED THEREIN NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

NCR: Yes / No

## WORK ORDER NON-CONFORMANCE / UPDATE

DQA: Date:

QA Closed: Date:

Work Order: _____				DISPOSITION		AGAINST DEPARTMENT/PROCESS					
				Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>		Engineering <input type="checkbox"/>		
				Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>		Quality <input type="checkbox"/>		
				Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>		Other <input type="checkbox"/>		
NCR No. _____				Work Order Update <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>				
Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector	
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear				General							
Bending		Bend		Grain		Ovalized		Pressure/Forced			
Centre Not Concentric to O/S		BOM/Route		Hardware		Over/Under tolerance		Temperature/Cure			
Cracks		Broken/Damaged		Inspection Incomplete		Part Incorrect		Weld			
Crushed/Crimped		Burrs		Instructions Incomplete/Unclear		Part Lost/Missing		Wrong Stock Pulled			
Cuffs		Contamination		Maintenance		Part Moved					
Heat Treat		Countersink		Mislabeled		Positioned Wrong					
Inspection Strip in Tube		Cut Too Short		Misread		Power Loss/Surge					
Ripples in Bend		Drill Holes		Offset							
Torque Waves in Extrusion		Drawing		Out of Calibration							
Turning Sequence		Finish		Out of Sequence							
Wave/Twist in Tube		Folio		Outside Dimensions							